

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012520**Date Inspected:** 16-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Gong liang zhu/ Mr. Li lin	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	Tower	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 10

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052930 perform SMAW repair welding on, CD corner of North tower, Lift 4, and weld joint identified as NSTL4-3 B/L-1A. ZPMC CWI Identified as Mr. Gong liang zhu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair.

Bay no. 11

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040699 perform SAW welding on, Spare strut splice plate, and weld joint identified as ED1-SA4-68-135 mtr.-6-1B. ZPMC CWI Identified as Mr. Mao Bin Bin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3221-TC-U5-S-1. (Photo attached)

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066361 perform SMAW repair welding on, BC corner of West tower, Lift 4, and weld joint identified as WSTL4-2 B/L-58A. ZPMC CWI Identified as Mr. Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair.(Photo attached)

WELDING INSPECTION REPORT

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Heavy Dock Jetty

4.This QA inspector, Baskar Govindarajan performed dimension measurements of Gap and misalignment of Interior splice plates between East tower Lift 1 and Lift 2 from inside. The same was measured from Top and bottom side of interior splice plates over the stiffeners of all the skins, i.e. Skin A to E. These measurements have been carried out along with QA Inspector Mr. Pillai whose lot no. is B286. Thickness of all stiffeners found to be 70 mm and the maximum Gap between stiffener to Interior splice plate on both top and bottom found to be 9.8mm and the minimum found to be 0mm. The maximum misalignment between stiffener to Interior splice plate on both top and bottom found to be 7 mm and the minimum found to be 0.5 mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
